

Work Order ID 149178

149178

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July 20, 2016 2:26:04 PM

Item ID: PB67-43001-07 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Fwd Blade Fold Assembly Weldment
 Start Date: 7/20/2016 Start Qty: 2.00 ***2*** Cust Item ID:
 Required Date: 8/3/2016 Req'd Qty: 2.00 ***2*** Customer:
 Reference:

Approvals: Process Plan: SW Date: 7/20/16 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
B67-43001-07	D

100

Weld per dwg A/R Aluminum rod Batch: 134806 0.00

100

Large Fab

Large Fab

Large Fab

Memo

0.13

1- Assemble parts on jig DT8813 and weld as per dwg PB67-43001

*** Ensure no burn thru after welding in tube -205 and -197 only where bushing -265 ***

JUL 28 2016

DAS
24
9-89

2 16-07-20

110

QC9- Inspect visual per QSI004- Fusion Welds

0.00

110

QC

Quality Control

Memo

0.00

DAS
9
9-89

16-07-29

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐				
OTHER : _____					

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 Start Date: 7/20/2016 Start Qty: 2.00 ***2*** Cust Item ID:
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 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC5- Inspect part completeness to step on W/O	0.00							
120									
QC	Memo	0.01							
Quality Control									

DAS
9
9-89

130	Green Sandtex(Ref:4.3.5.8) per QSI005 4.3	0.00							
130									
Powdercoat	Memo 11134092	0.03							
Powder Coating	***MASK ALL OPENING AND INDICATED AREAS PRIOR TO POWDERCOATING, SEE NOTE 9 SHEET 2-3****								
	START TIME: 2:00pm								
	OVEN TEMPERATURE: 320°F								
	FINISH TIME: 2:30pm								

XZ of del 16/08/12

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : _____					

Work Order ID 149178

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Item ID: PB67-43001-07

Accept

N900040100

Setup

Start

NS1

Revision ID:

Stop

NS2

Item Name: Fwd Blade Fold Assembly Weldment

Start Date: 7/20/2016 Start Qty: 2.00

2

Cust Item ID:

Required Date: 8/3/2016 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run

Start

NR1

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140	QC3- Inspect Part Finish	0.00							DAS 38 9-89
140									
QC	Memo	0.00							
Quality Control									AUG 23 2016
150	Identify as per dwg & Stock Location: <u>MEZ32</u>	0.00							
150									
Packaging	Memo	0.00							
Packaging									
160	QC21- Final Inspection - Work Order Release	0.00							
160									
QC	Memo	0.03							
Quality Control									

DAS
21
9-89

AUG 24 2016

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
240 PS 2105 P 3 QUA				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : _____					

Picklist Print

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Page 1

Work Order ID: 149178

149178

Parent Item: PB67-43001-07

PB67-43001-07

Parent Item Name: Fwd Blade Fold Assembly Weldment

Start Date: 7/20/2016

Required Date: 8/3/2016

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:A 08-06-25 new issue DD verified by:ec IPP rev B
10.09.24 per revC dwg EC verified by:DD IPP REV:C 14.12.15
DWG REV.D DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

PB67-43001-205W		Manufactured	No				Each	2.0000		2			
PB67-43001-205W									**	JUL 28 2016			DAS 24 9-89
Outer Tube Weldment													

Location Loc Qty Loc Code

Mezz2 2
142222 2

PB67-43001-197W		Manufactured	No			100	Each	2.0000	1	2			
PB67-43001-197W									**	JUL 28 2016			DAS 24 9-89
Outer Tube Weldment													

Location Loc Qty Loc Code

Mezz2 2
142221 2

PB67-43001-203W		Manufactured	No			100	Each	4.0000	1	2			
PB67-43001-203W									**	JUL 28 2016			DAS 24 9-89
Square Tube Weldment													

Location Loc Qty Loc Code

MEZZ 4
139208 4

PB67-43001-207W		Manufactured	No			100	Each	2.0000	1	2			
PB67-43001-207W									**	JUL 28 2016			DAS 24 9-89
Square Tube Weldment													

Location Loc Qty Loc Code

Mezz 2
148806 2

Picklist Print

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Page 2

Work Order ID: 149178

149178

Parent Item: PB67-43001-07

PR67-43001-07

Parent Item Name: Fwd Blade Fold Assembly Weldment

Start Date: 7/20/2016

Required Date: 8/3/2016

Start Qty: 2.00

Required Qty: 2.00

PB67-43001-47

Manufactured No

100 Each 0.0000 1 2

DAS
24
9-89

PR67-43001-47

Base Assembly

B 148803 → ** 2

2 JUL 28 2016

PB67-43001-201

Manufactured No

100 Each 3.0000 1 2

DAS
24
9-89

PR67-43001-201

Square Tube

**

JUL 28 2016

Location

Loc Qty

Loc Code

Mezz2

3

139209

3

PB67-43001-209

Manufactured No

100 Each 2.0000 1 2

DAS
24
9-89

PR67-43001-209

Square Tube

**

JUL 28 2016

Location

Loc Qty

Loc Code

Mezz2

2

139206

2

PB67-43001-211

Manufactured No

100 Each 18.0000 6 12

DAS
24
9-89

PR67-43001-211

Square Tube

**

JUL 28 2016

Location

Loc Qty

Loc Code

Mezz2

18

139201

18

PB67-43001-219

Manufactured No

100 Each 1.0000 1 2

DAS
24
9-89

PR67-43001-219

Angled Male Eye

**

JUL 28 2016

Location

Loc Qty

Loc Code

Mezz2

1

133668

1

B 148807 →

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Shop Packet Print

Page 2

Picklist Print

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Page 3

Work Order ID: 149178

149178

Parent Item: PB67-43001-07

PB67-43001-07

Parent Item Name: Fwd Blade Fold Assembly Weldment

Start Date: 7/20/2016

Required Date: 8/3/2016

Start Qty: 2.00

Required Qty: 2.00

D3440-7

Manufactured No

100 Each

6.0000 1 2

D3440-7

Detent Clip Base (Supersedes B67-43001-221)

JUL 28 2016

DAS

24

9-89

Location

Loc Qty

Loc Code

Mezz2

6

141958

6

2

D3440-5

Manufactured No

100 Each

6.0000 1 2

D3440-5

Contoured Detent Clip Base (Supersedes B67-43001-217)

JUL 28 2016

DAS

24

9-89

Location

Loc Qty

Loc Code

Mezz2

6

141957

6

2

D3440-15

Manufactured No

100 Each

6.0000 1 2

D3440-15

Contoured Male Eye (Supersedes B67-43001-215)

JUL 28 2016

DAS

24

9-89

Location

Loc Qty

Loc Code

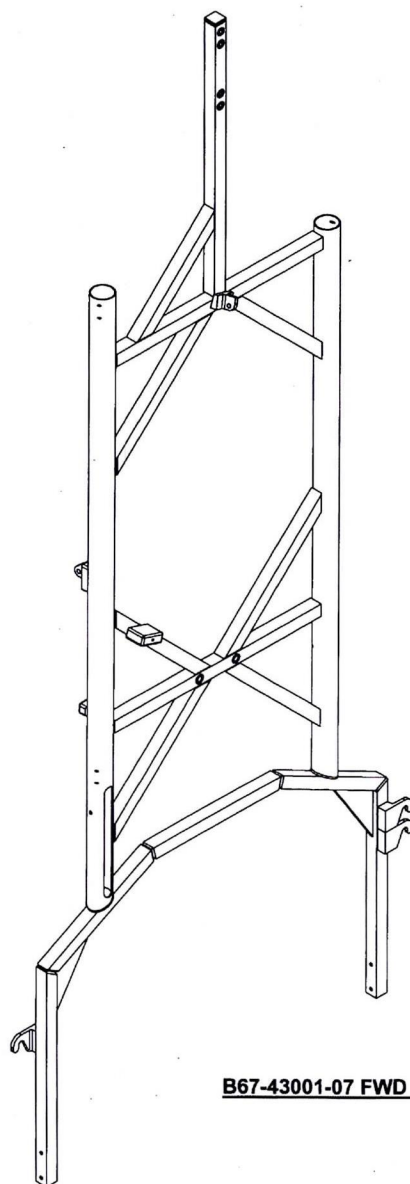
Mezz2

6

141956

6

2



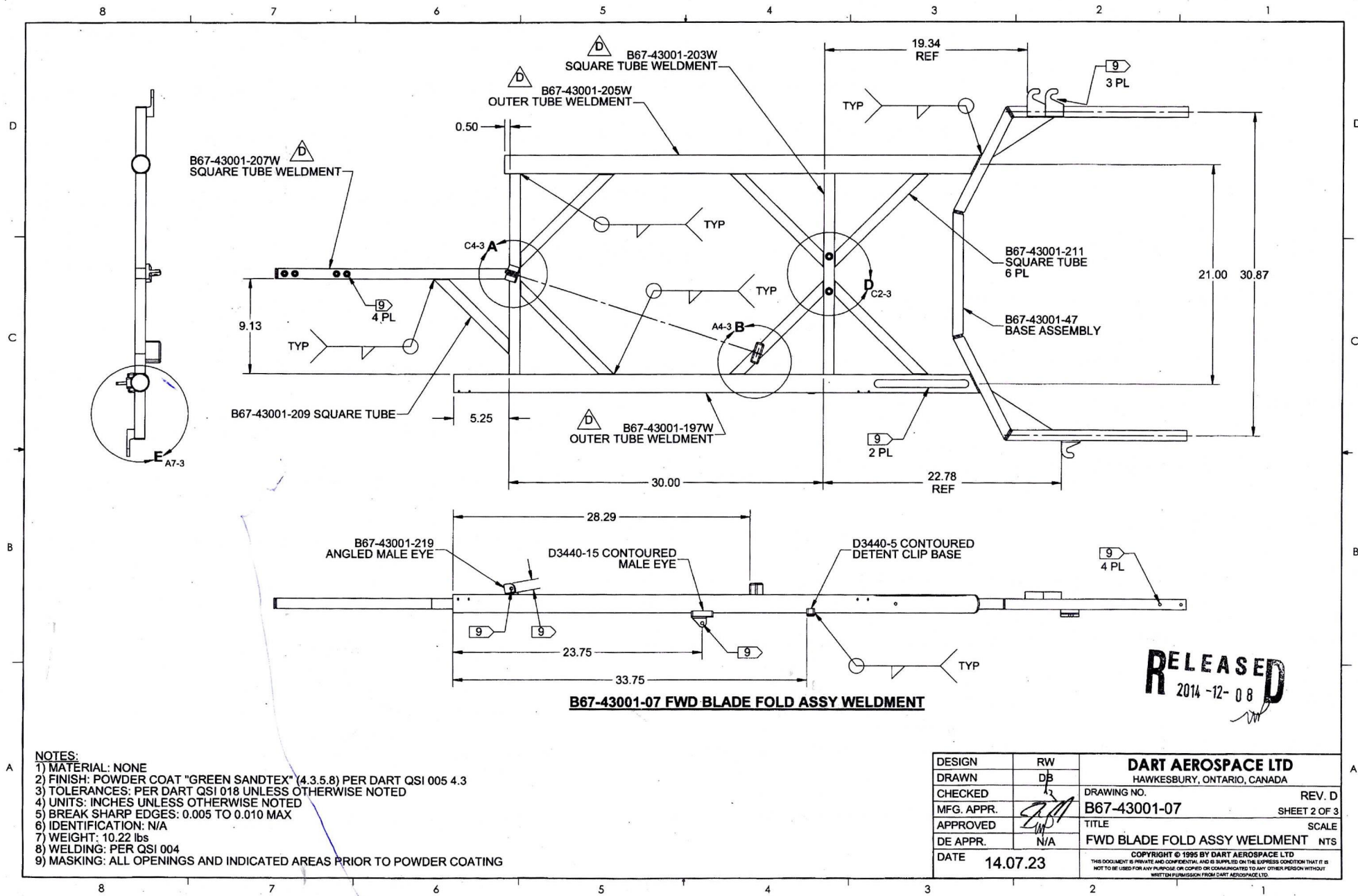
B67-43001-07 FWD BLADE FOLD ASSY WELDMENT

ITEM	QTY -07	P/N	DESCRIPTION
1	X	B67-43001-07	FWD BLADE FOLD ASSY WELDMENT
2	1	B67-43001-47	BASE ASSEMBLY
3	1	B67-43001-197W	OUTER TUBE WELDMENT
4	1	B67-43001-201	SQUARE TUBE
5	1	B67-43001-203W	SQUARE TUBE WELDMENT
6	1	B67-43001-205W	OUTER TUBE WELDMENT
12	1	B67-43001-207W	SQUARE TUBE WELDMENT
8	1	B67-43001-209	SQUARE TUBE
9	6	B67-43001-211	SQUARE TUBE
10	1	B67-43001-219	ANGLED MALE EYE
11	1	D3440-5	CONTOURED DETENT CLIP BASE
12	1	D3440-7	DETENT CLIP BASE
13	1	D3440-15	CONTOURED MALE EYE

RELEASED
2014-12-08

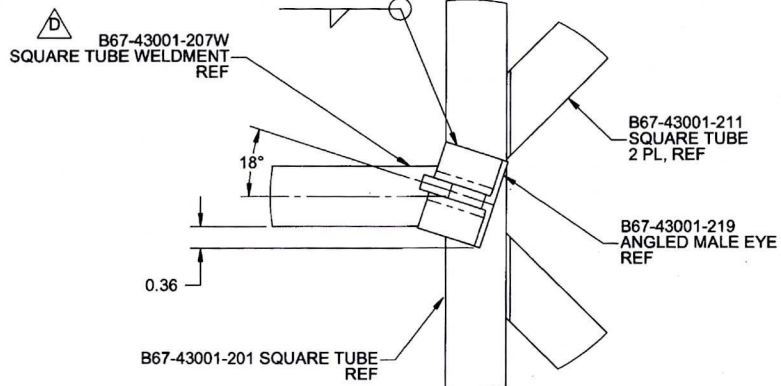
SH 7/20/16
149178

D	REVISE BOM AND ANNOTATIONS TO INCLUDE -197W/-203W/-205W & -207W WELDMENTS, DELETE DETAIL C REASON: TO FACILITATE MANUFACTURING	DB	14.07.23
C	REDRAWN PREMIER AVIATION DRAWING IAW DART QSI 018 AND QSI 043. FOR PREVIOUS REVISIONS, REFER TO SHEET 5 OF PREMIER AVIATION DRAWING # B67-43001. REASON: SEE PAR #09-011	MB	10.05.04
REV.	DESCRIPTION	BY	DATE
DESIGN	RW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	DB		
CHECKED		DRAWING NO.	REV. D
MFG. APPR.		B67-43001-07	SHEET 1 OF 3
APPROVED		TITLE	SCALE
DE APPR.	N/A	FWD BLADE FOLD ASSY WELDMENT	NTS
DATE	14.07.23	COPYRIGHT © 1985 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

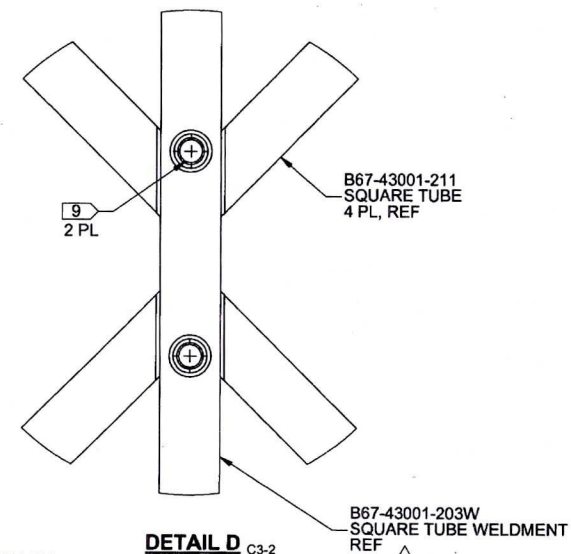


RELEASED
2014-12-08

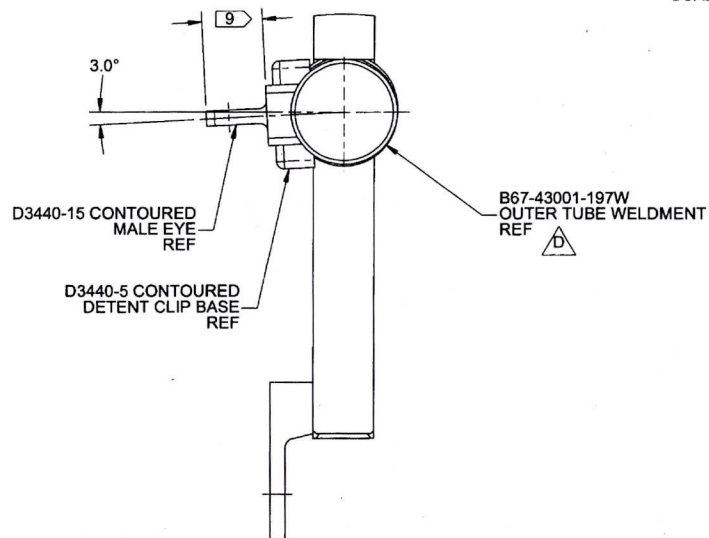
DESIGN	RW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	DB		
CHECKED		DRAWING NO.	REV. D
MFG. APPR.		B67-43001-07	SHEET 2 OF 3
APPROVED		TITLE	SCALE
DE APPR.	N/A	FWD BLADE FOLD ASSY WELDMENT	NTS
DATE	14.07.23	COPYRIGHT © 1995 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



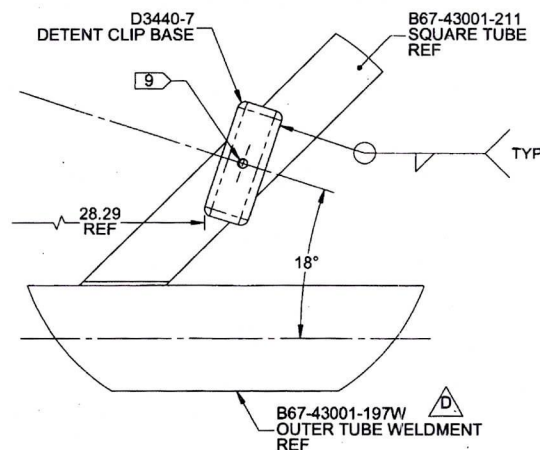
DETAIL A
SCALE 4X C6-2



DETAIL D
SCALE 4X C3-2



DETAIL E
SCALE 4X B8-2



DETAIL B
SCALE 4X C4-2

RELEASED
2014-12-08

DESIGN	RW	DART AEROSPACE LTD	
DRAWN	DB	HAWKESBURY, ONTARIO, CANADA	
CHECKED	1	DRAWING NO.	REV. D
MFG. APPR.		B67-43001-07	SHEET 3 OF 3
APPROVED		TITLE	SCALE
DE APPR.	N/A	FWD BLADE FOLD ASSY WELDMENT	NTS
DATE	14.07.23	COPYRIGHT © 1995 BY DART AEROSPACE LTD	
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